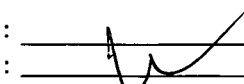
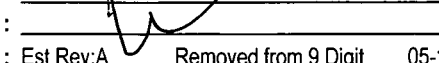


Date: Tuesday, 10/03/2009 7:10:05 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: "T" HANDLE ASSEMBLY
Job Number	: 46369		
Estimate Number	: 11179		
P.O. Number	:	Part Number	: D2282041
This Issue	: 10/03/2009 S.O. No. :	Drawing Number	: D2282 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: E
Previous Run	: 45347A	Material	:
Written By	: 	Due Date	: 17/03/2009 Qty: 11 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D22823	Tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 11.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2282-3	Handle tube	B45384 = 11x

SP 09.03.10

2.0	D22825	Tube
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 11.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D2282-5	Handle tube	B45385 = 11x

SP 09.03.10

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-041 'T' Handle Assembly
Grind chamfers and ensure full penetration.as per dwg D2282
*****brush weld right after welding, to take color off *****

A/R ER316L SS Filling Rod M106115
Dwg Rev: E

SP 09.03.10

11x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/03/2009 7:10:05 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: "T" HANDLE ASSEMBLY

Job Number: 46369

Part Number: D2282041

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC9

VISUAL WELDING INSPECTION



(X11)

Comment: VISUAL WELDING INSPECTION

Cpl 09-03-10

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

LB 9-3-12

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09-03-12 (11)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(11K)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5/13/13

sf

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(11)

Comment: FINAL INSPECTION/W/O RELEASE

09/03/15

Job Completion



mt 09-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

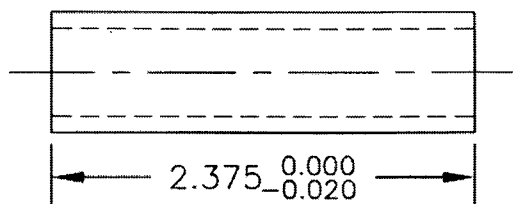
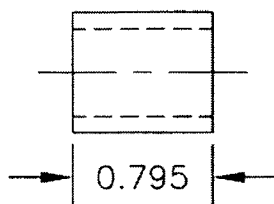
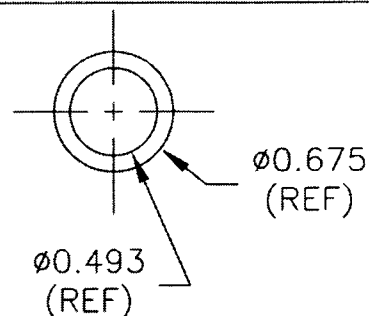
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

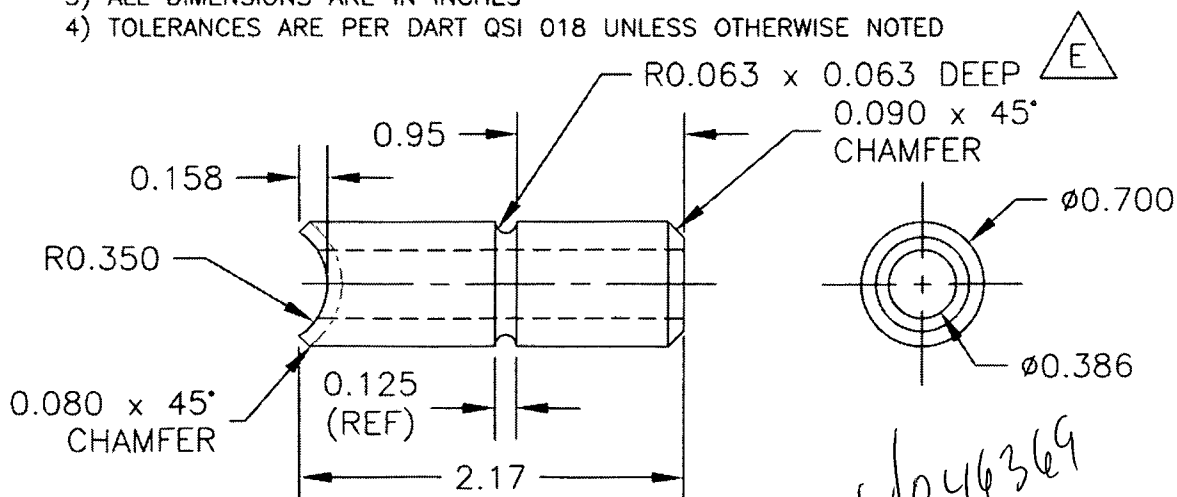
NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 1 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1
A	94.10.14	NEW ISSUE	
B	95.03.23	RE-DESIGN	
C	97.10.20	CORRECTED NUMBERING SCHEME	
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750	
E	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030	

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

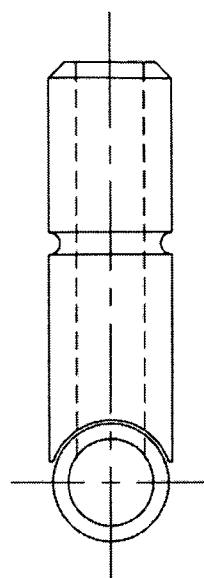
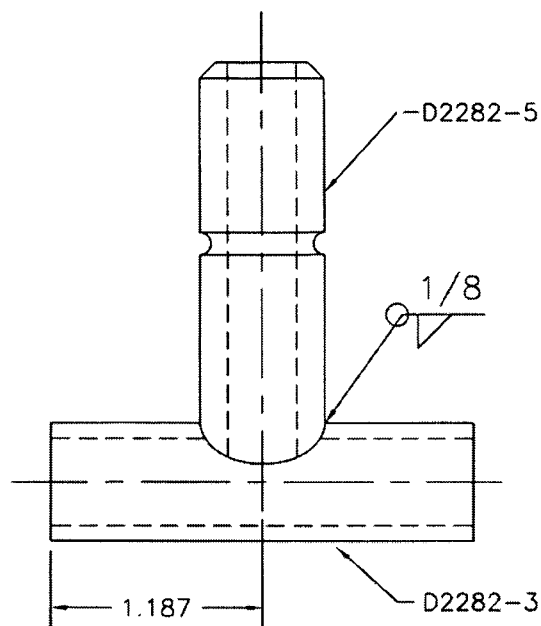
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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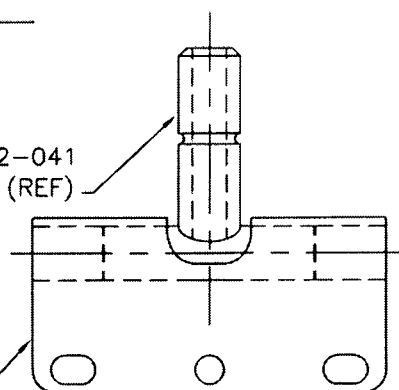
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DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07	TITLE HANDLE TUBES		SCALE 1:1

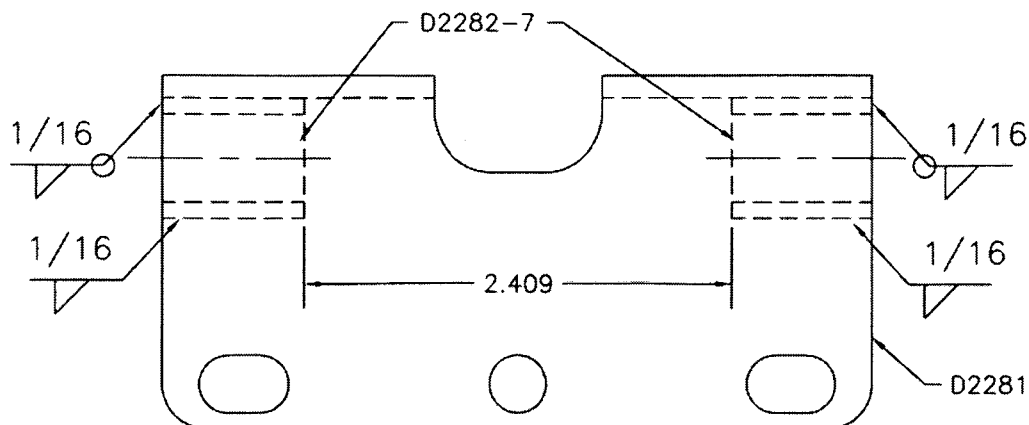


D2282-041
(REF)



D2282-041 'T' ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

GENERAL ASSEMBLY
SCALE 1:2



D2282-043 SADDLE ASSEMBLY
WELD ASSEMBLY PER DART QSI 004

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